

# Work Order ID 86964

**\*86964\***

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July-10-12 9:08:56 AM

Item ID: D3066-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacer  
 Start Date: 7/10/12 Start Qty: 60.00 **\*60\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 60.00 **\*60\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3066	Rev B								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							B12-7-11
FLOW CNC Waterjet	1-Cut as per Dwg D3066								
6061.08	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							B12-7-11
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
16  
9-89

12/09/13

Count  
(x98)  
2849

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*86964\***

July-10-12 9:08:56 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**\*60\***

**Cust Item ID:**

**\*60\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

0.00

**\*130\***

HandFinish

## Memo

0.00

## Hand Finishing

140

### QC3- Inspect Part Finish

0.00

\*140\*

OC

## Memo

0.00

## Quality Control

150

Identify as per dwg & Stock Location: WA

0.00

**\*150\***

### Packaging

## Memo

0,00

### Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 86964****\*86964\***

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July-10-12 9:08:56 AM

Item ID: D3066-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacer

Start Date: 7/10/12 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/7/18   
12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

July-10-12 9:08:56 AM

Page 1

Work Order ID: 86964

Parent Item: D3066-1

Parent Item Name: Spacer

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF  
IPP Rev:B Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bia Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	314.8743	0.0945	5.968422	10	8-7-11	

Location

Loc Qty

Loc Code

MAT021

314.874316

117285

0.124316

119766

39.6

120096

261.45

121193

13.7

170096

68

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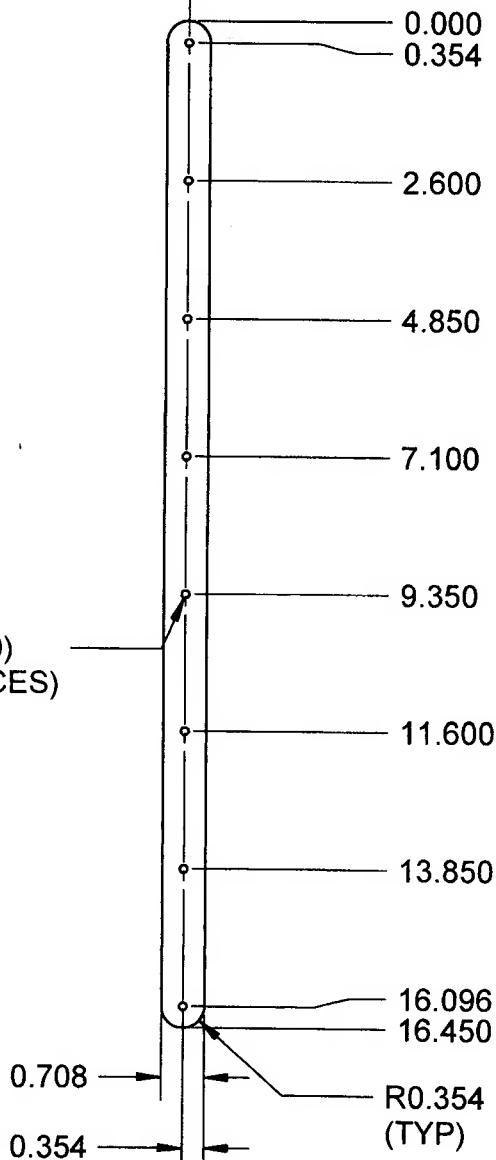


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3066</b>	REV. B
DATE <b>06.05.29</b>		TITLE <b>SPACER</b>	SHEET 1 OF 1 SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

*de. de. 20* *[Signature]*

Ø 0.128 (#30)  
(TYP 8 PLACES)



SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *210910*  
*MCS*  
*12/07/10*

**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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